

Pickup Box Outer Side Panel

Special Tool(s) / General Equipment

6.5 mm Drill Bit
Rivet Gun
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
MIG/MAG Welding Equipment
Locking Pliers

Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M [®] , 08115, LORD Fusor [®] 108B	-
Flexible Foam Repair 3M [®] , 08463, LORD Fusor [®] 121	-

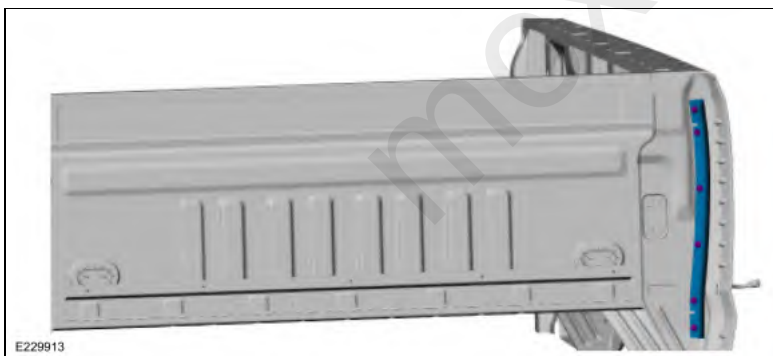
Removal

NOTE: Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

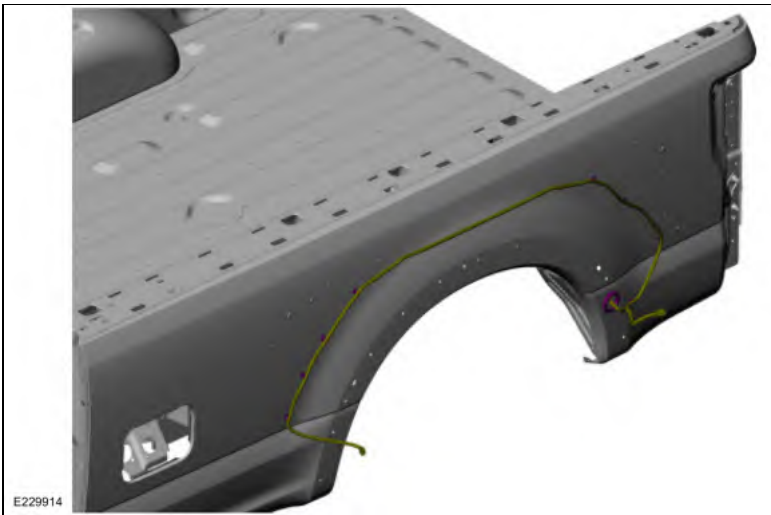
NOTE: 8.0 foot pickup box with dual rear wheels shown, all others similar.

NOTE: LH side shown, RH side does not include fuel fill.

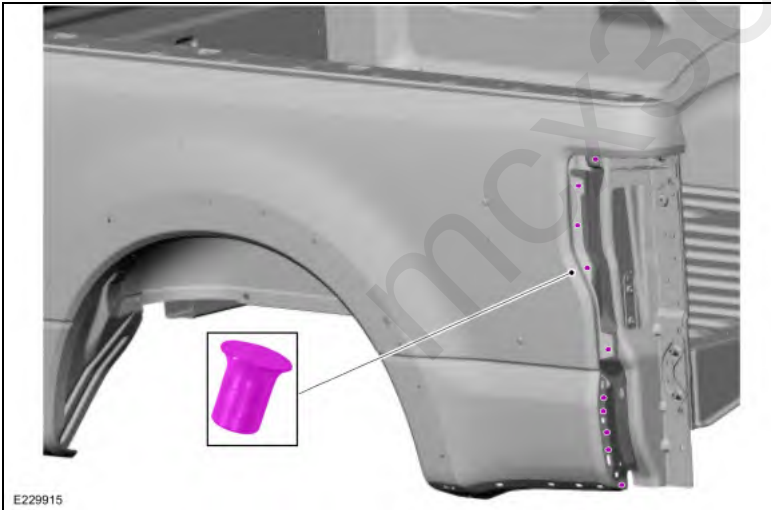
1. Remove the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Description and Operation).
2. Remove the cab-to-pickup box seal.



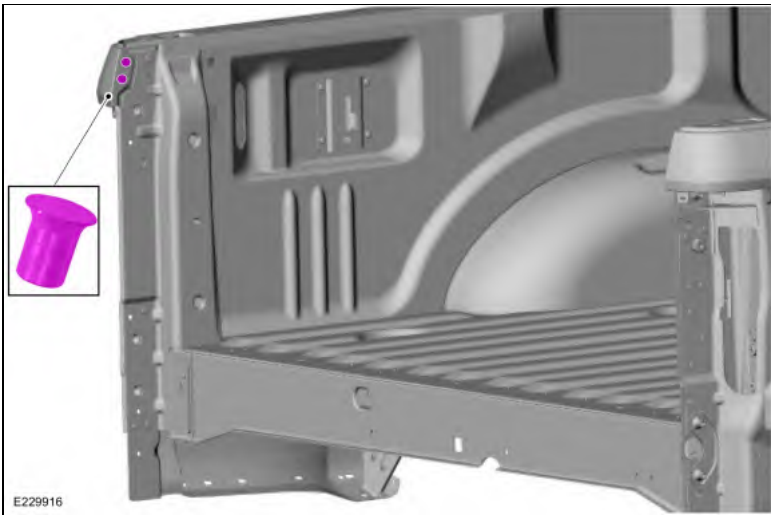
3. Dual rear wheels only.
Remove the pickup box dual rear wheels fender.
Refer to: Fender (501-04 Pickup Bed and Platform Body, Removal and Installation).
4. Dual rear wheels only.
Remove the fasteners and position aside the dual rear wheels wiring harness.



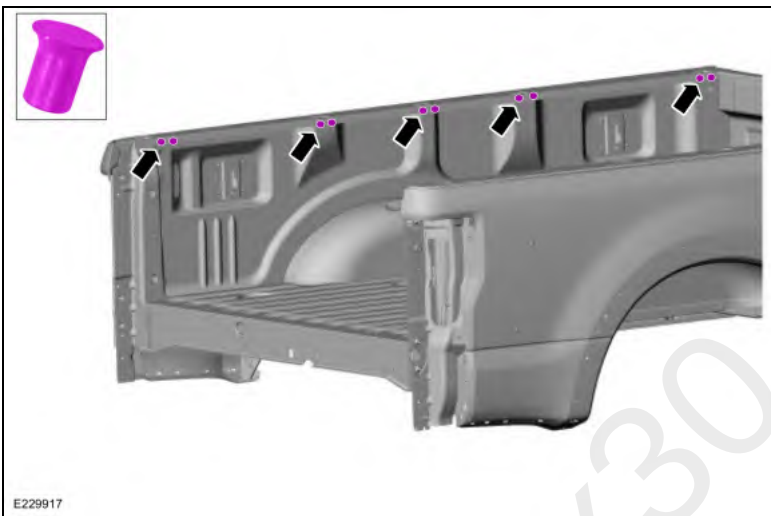
5. Remove the tailgate.
6. Remove the tail lamp assembly.
Refer to: Rear Lamp Assembly (417-01 Exterior Lighting, Removal and Installation).
7. LH side only.
Remove the fuel fill door and fuel fill cup.
Refer to: Fuel Filler Door (501-03 Body Closures, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Midship Fuel Tank (310-01A Fuel Tank and Lines - 6.2L V8, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Aft of Axle Fuel Tank (310-01A Fuel Tank and Lines - 6.2L V8, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Midship Fuel Tank (310-01B Fuel Tank and Lines - 6.7L Power Stroke Diesel, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Aft of Axle Fuel Tank (310-01B Fuel Tank and Lines - 6.7L Power Stroke Diesel, Removal and Installation).
8. Remove the top rail cover, wheel house opening and lower side trim.
Refer to: Rear Quarter Panel Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).
9. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



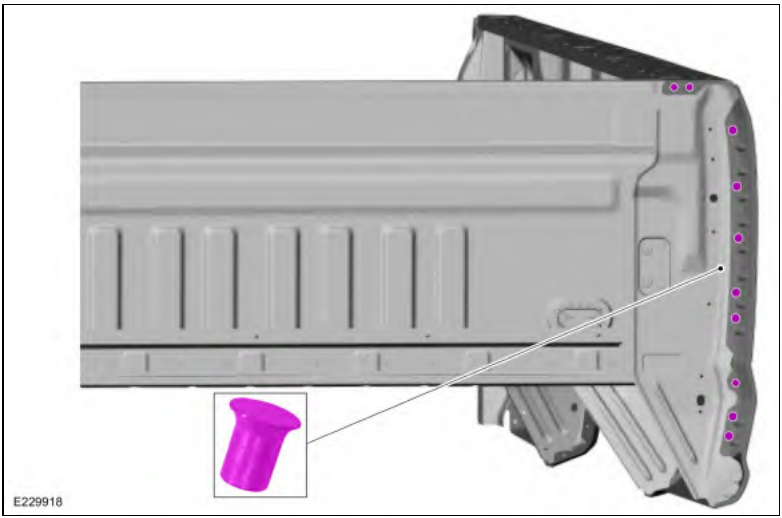
10. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



11. Remove the SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



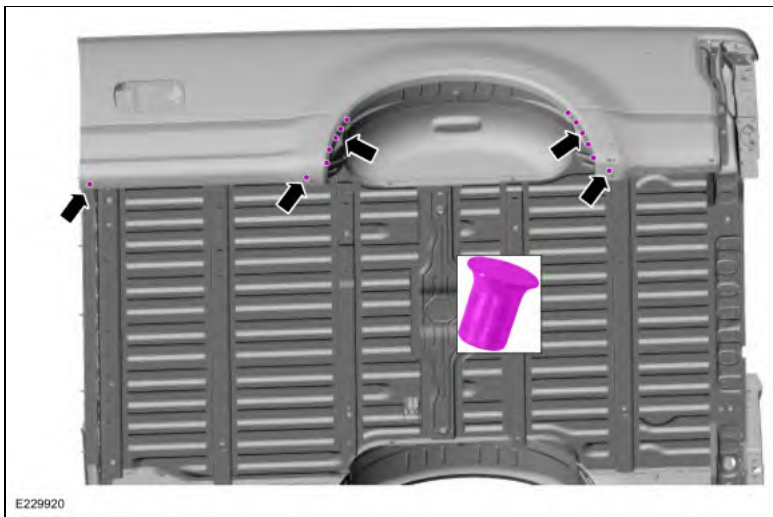
12. Remove the SPR fasteners.
 Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
 Use the General Equipment: Belt Sander



13. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



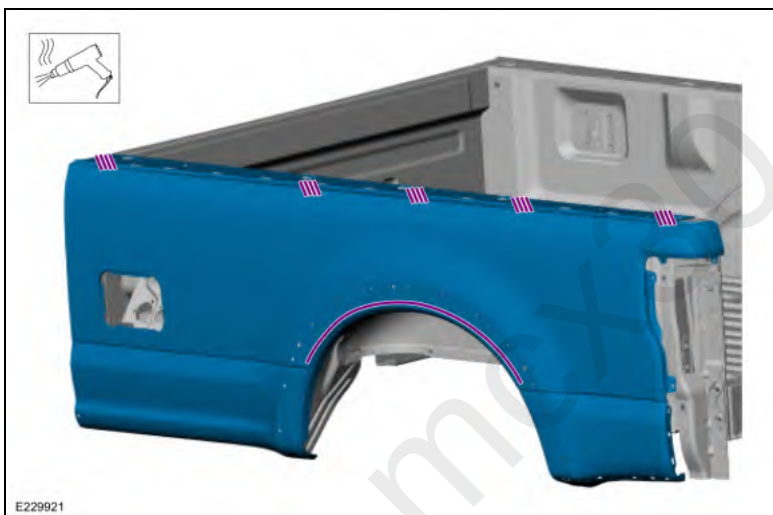
14. Remove the SPR fasteners.
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer
Use the General Equipment: Belt Sander



15. **NOTE:** Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425°F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

NOTE: Note the location of adhesives, NVH pads and sealers to aid in installation.

Break the adhesive bond and remove the pickup box outer side panel.
Use the General Equipment: Hot Air Gun



Installation

NOTE: 8.0 foot pickup box with dual rear wheels shown, all others similar.

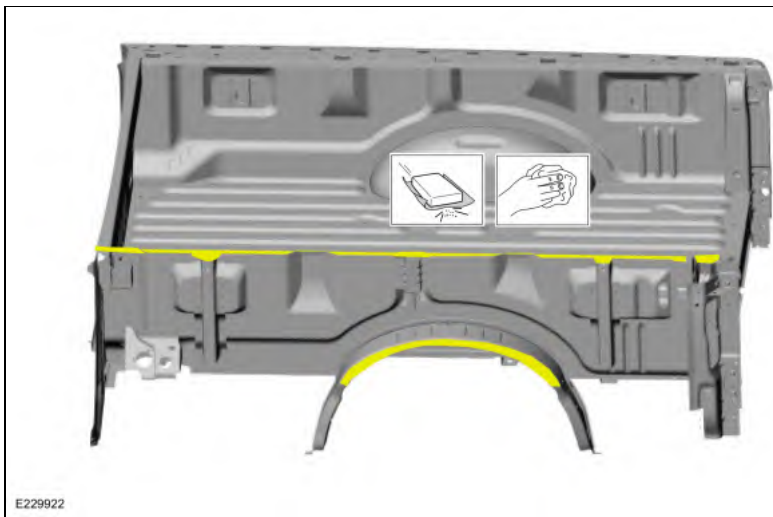
NOTE: LH side shown, RH side does not include fuel fill.

NOTE: SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

NOTE: Blind or solid rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Rivet-Bonding

- 80-120 grit sand paper.
Sand old adhesive and sealer at mating surfaces only and clean.



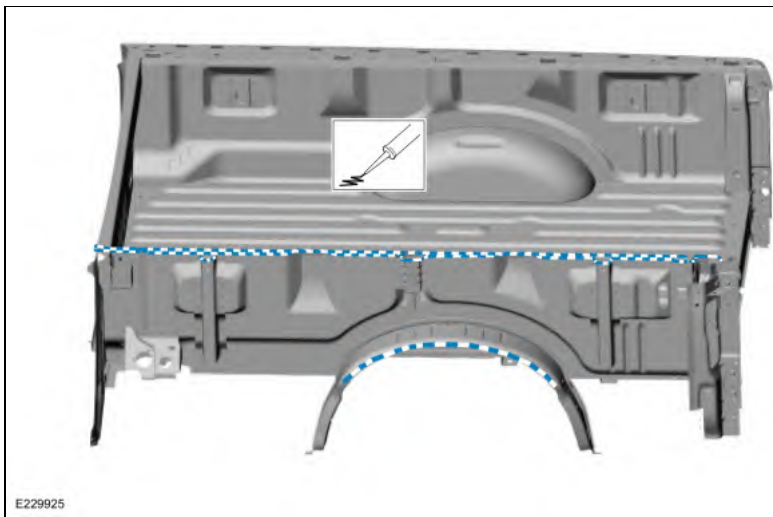
2. 80-120 grit sand paper.
Sand to remove e-coat at mating surfaces only and clean.



3. Install the NVH pad.

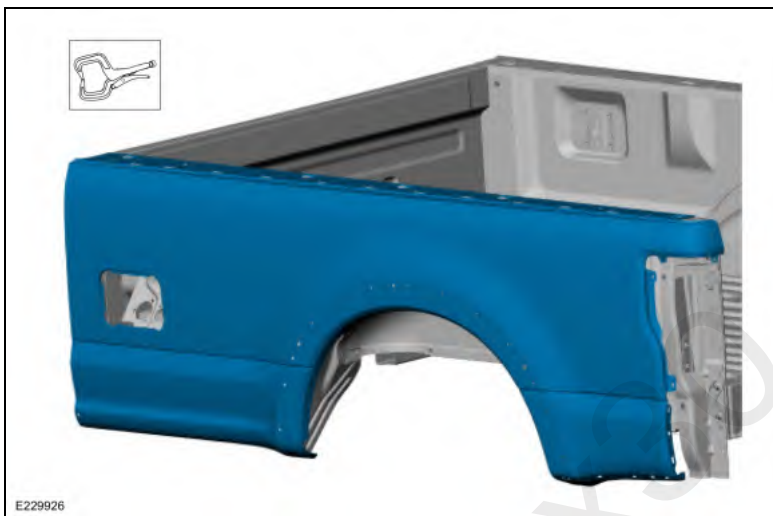


4. Apply adhesive.
Material: Metal Bonding Adhesive / TA-1, TA-1-B, 3M, 08115, LORD Fusor® 108B



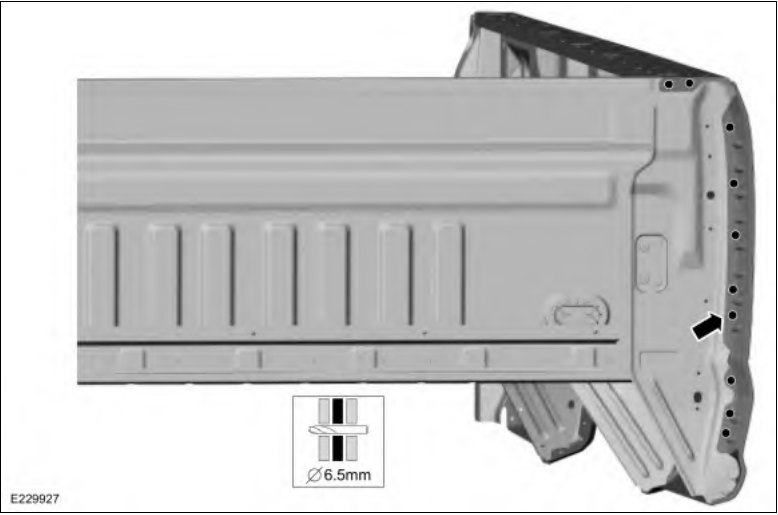
5. **NOTE:** Do not lift the panel to reposition. Slide panel to minimize potential for breaking the adhesive bond.

Install the replacement pickup box outer side panel and clamp in position.
Use the General Equipment: Locking Pliers

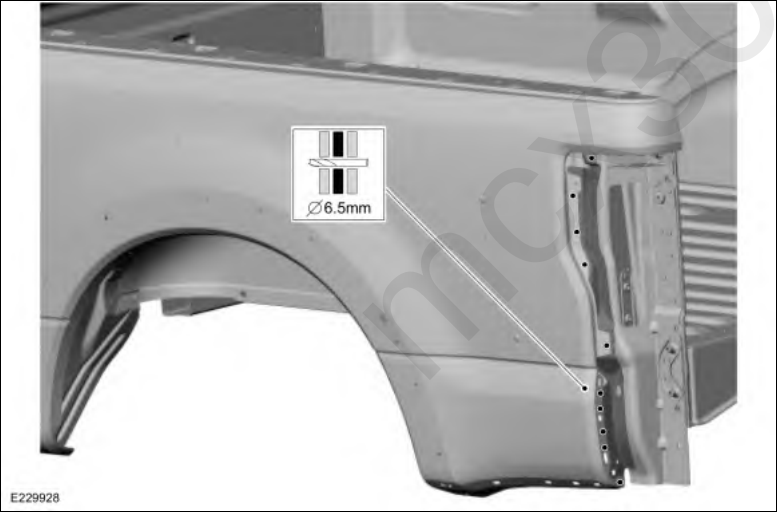


6. **NOTE:** Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

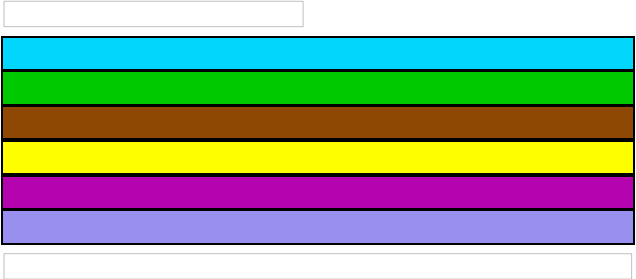
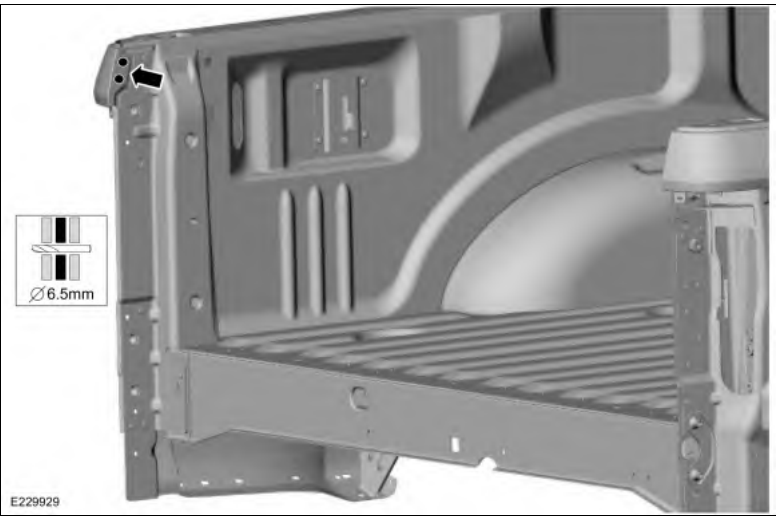
Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



7. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



8. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit

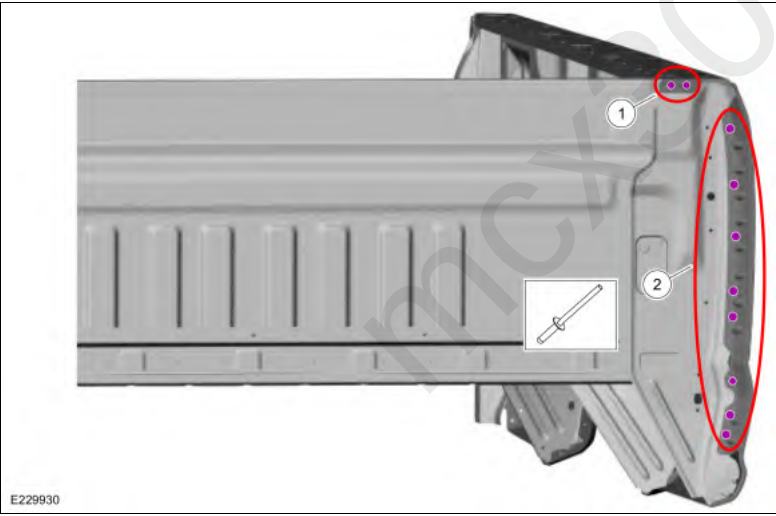


9. **NOTE:** Blind rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Rivet Gun

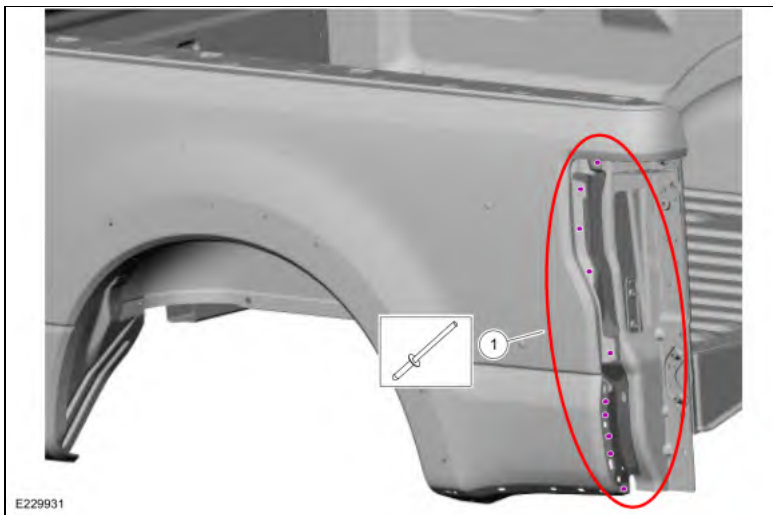


10. **NOTE:** Blind rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

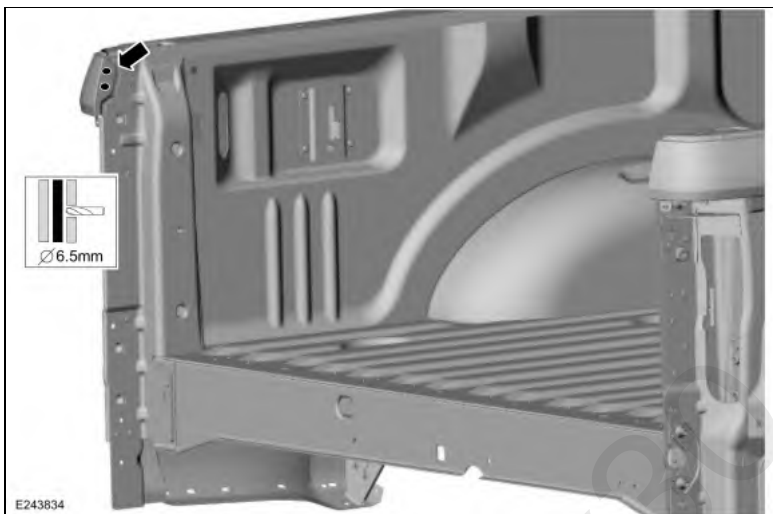
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

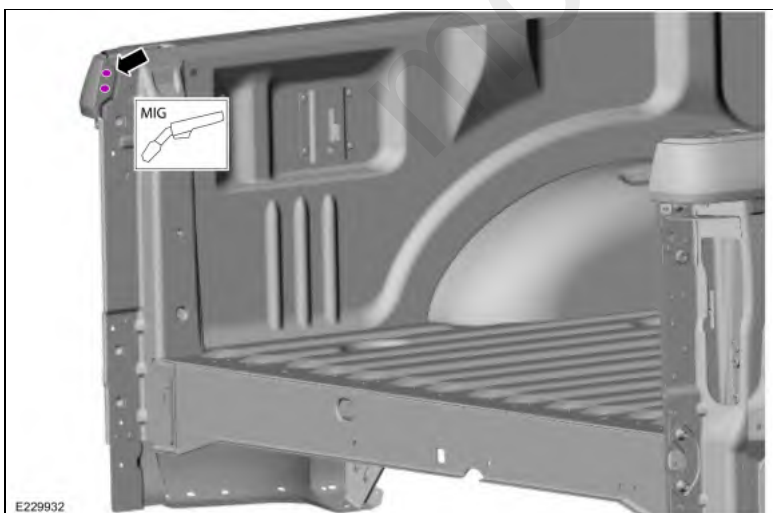
Use the General Equipment: Rivet Gun



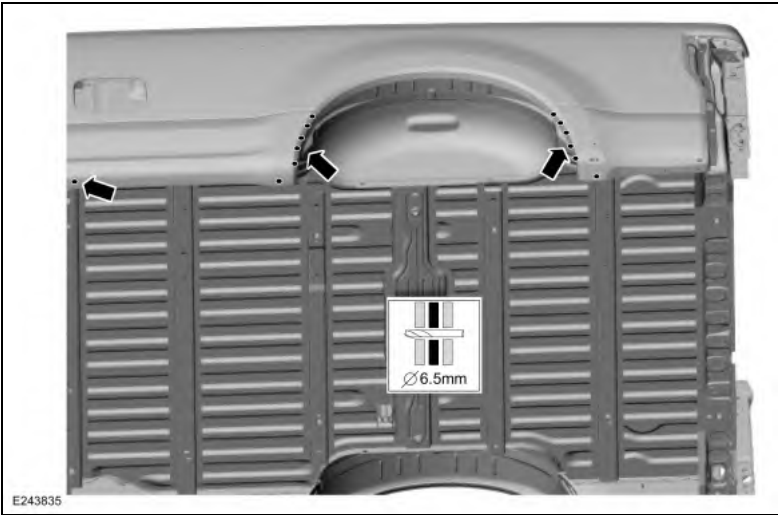
11. Drill plug weld holes.
Use the General Equipment: 6.5 mm Drill Bit



12. Install MIG plug welds.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).



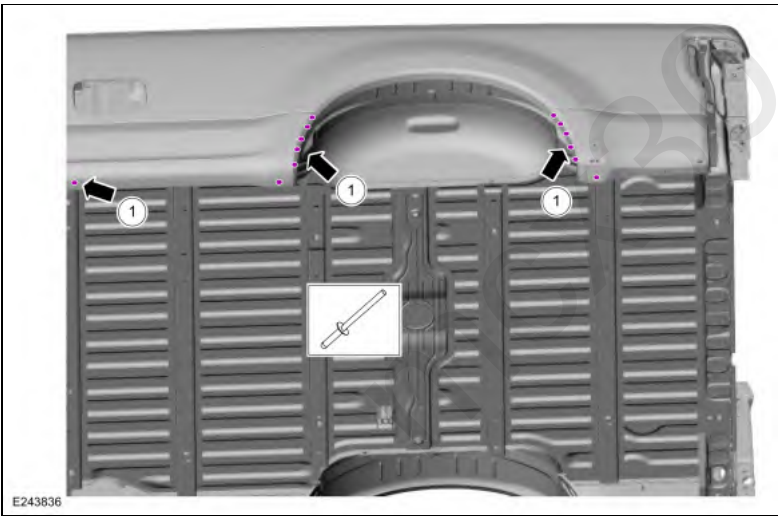
13. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit



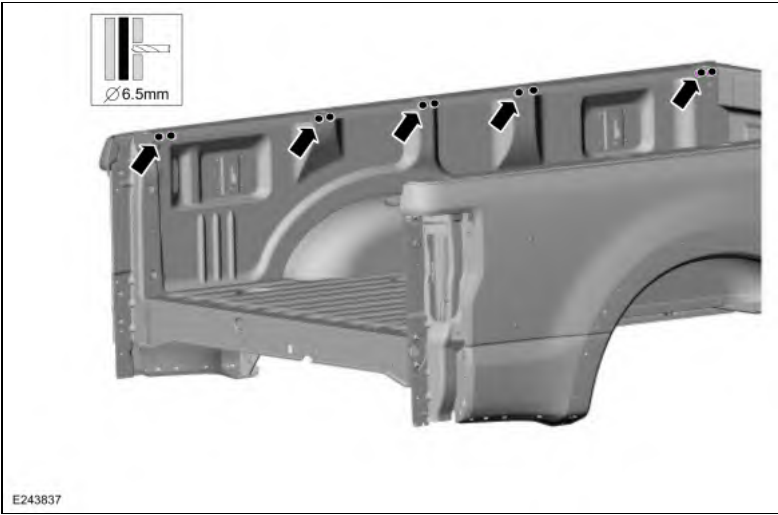
14. **NOTE:** Blind rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.
Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun



15. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit

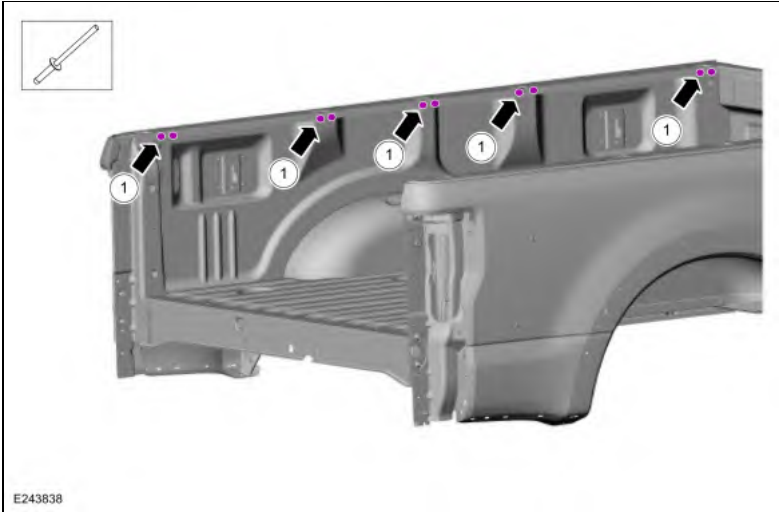


16. **NOTE:** Blind rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun



17. Drill for fastener installation.
Use the General Equipment: 6.5 mm Drill Bit

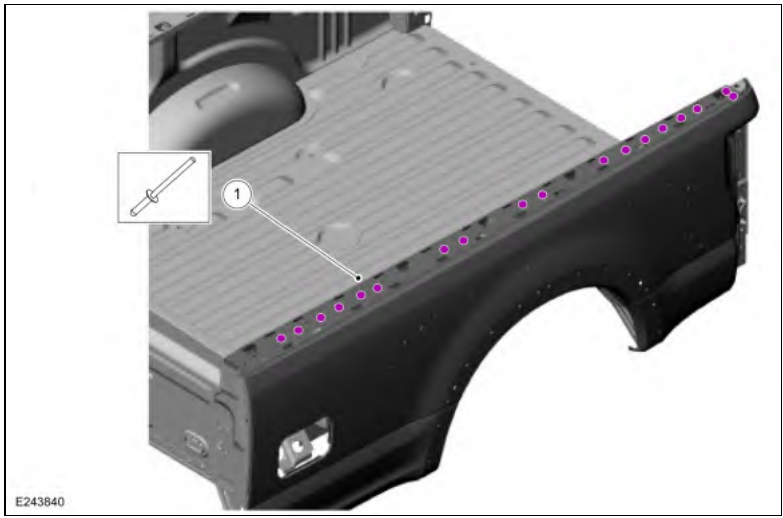


18. **NOTE:** Blind rivet fasteners or MIG plug welds may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

Install fasteners.

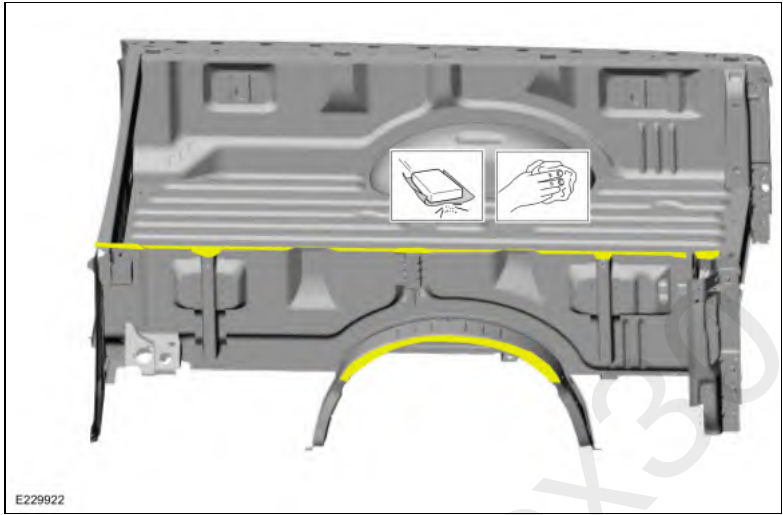
Item	SPR Number	SPR Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun



Plug-Welding

19. Sand to remove old adhesive and sealer at mating surfaces only and clean.



20. Install the NVH pad.



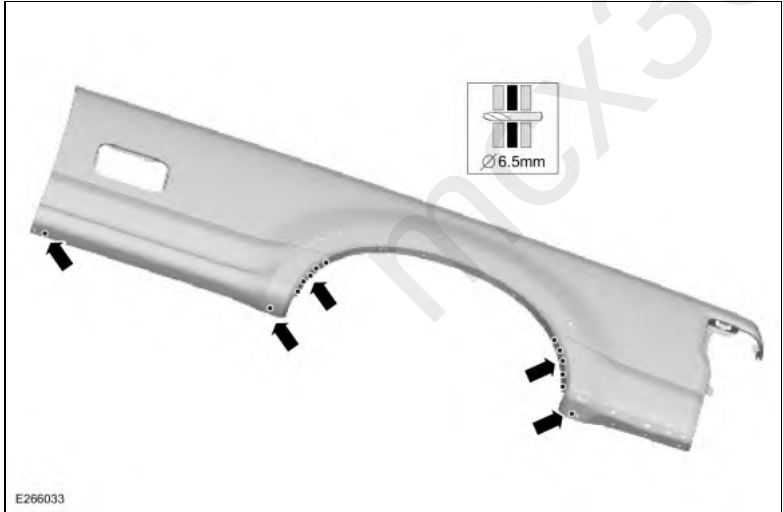
21. Drill plug weld holes.
Use the General Equipment: 6.5 mm Drill Bit



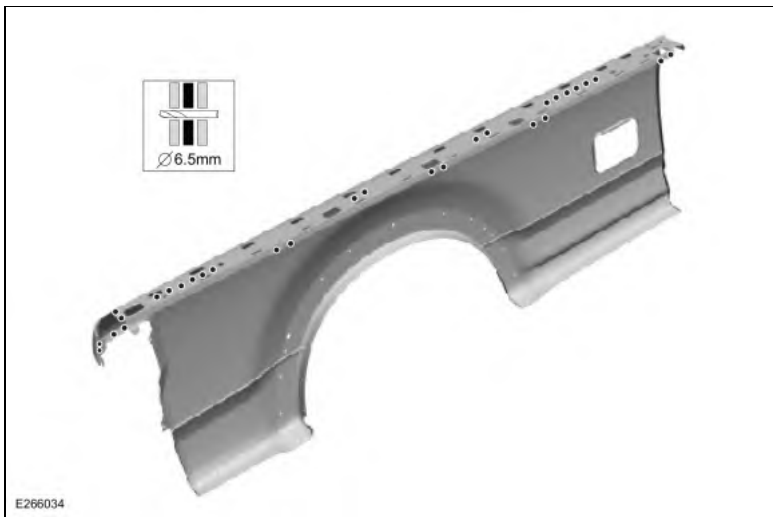
22. Drill plug weld holes.
Use the General Equipment: 6.5 mm Drill Bit



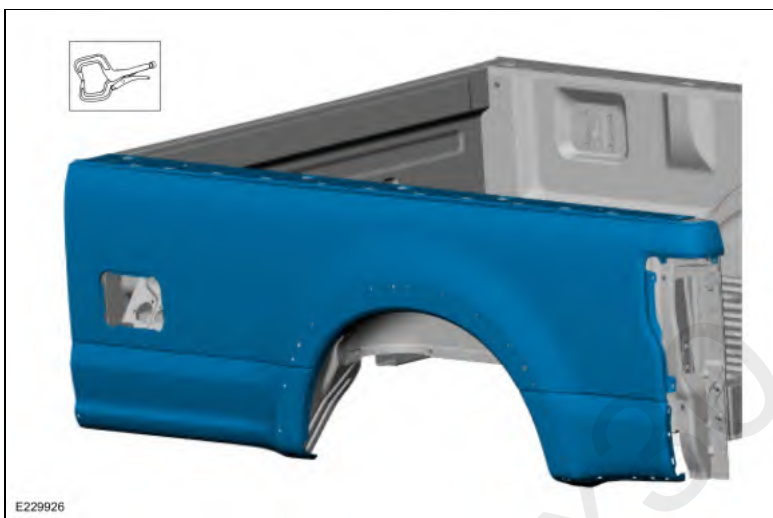
23. Drill plug weld holes.
Use the General Equipment: 6.5 mm Drill Bit



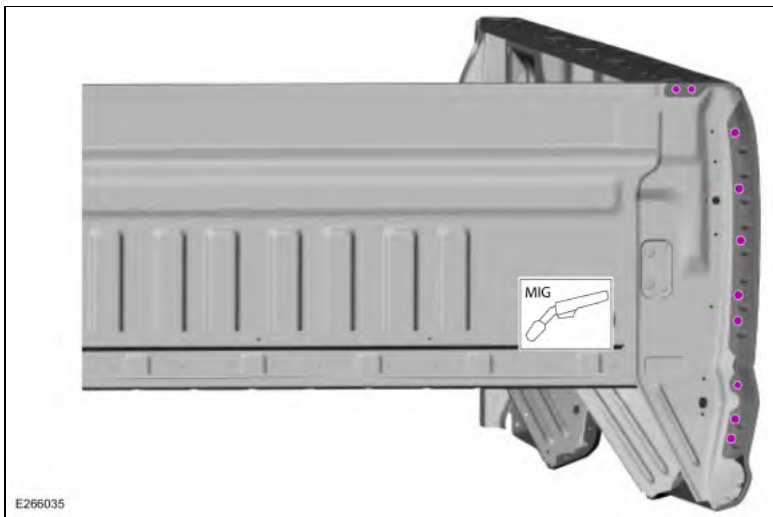
24. Drill plug weld holes.
Use the General Equipment: 6.5 mm Drill Bit



25. Install the replacement pickup box outer side panel and clamp in position.
Use the General Equipment: Locking Pliers



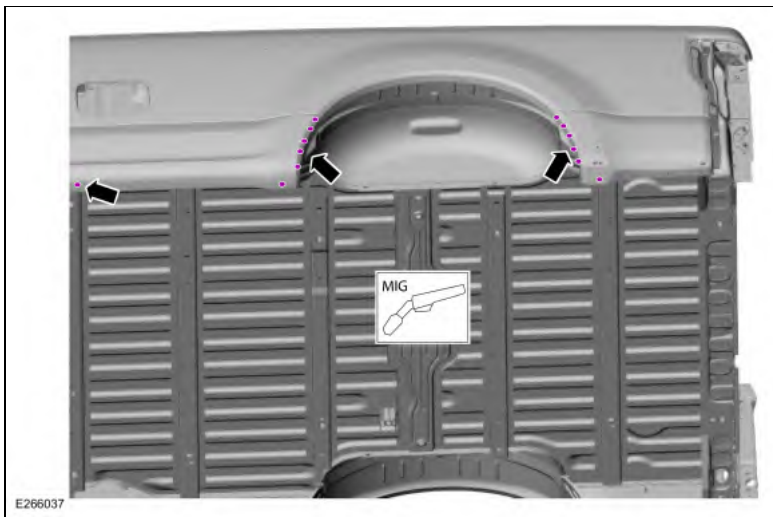
26. Install plug welds with a MIG welder set up for aluminum welding.
Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
Use the General Equipment: MIG/MAG Welding Equipment



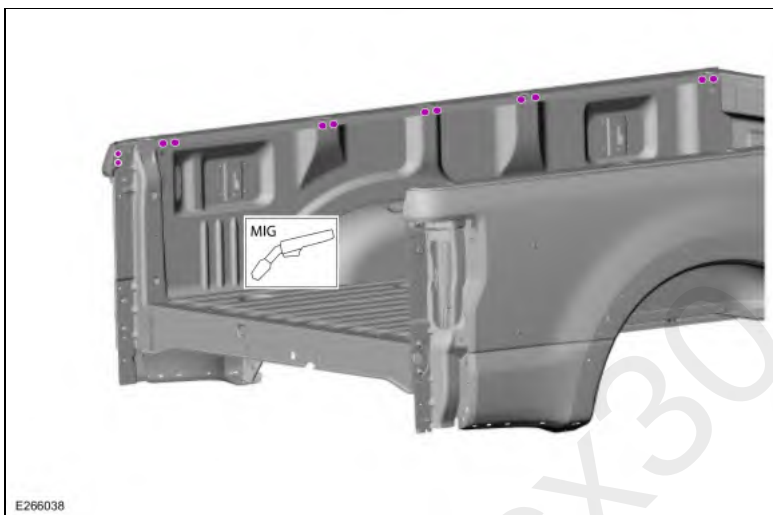
27. Install plug welds with a MIG welder set up for aluminum welding.
 Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
 Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
 Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
 Use the General Equipment: MIG/MAG Welding Equipment



28. Install plug welds with a MIG welder set up for aluminum welding.
 Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
 Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
 Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
 Use the General Equipment: MIG/MAG Welding Equipment



29. Install plug welds with a MIG welder set up for aluminum welding.
 Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
 Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
 Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
 Use the General Equipment: MIG/MAG Welding Equipment



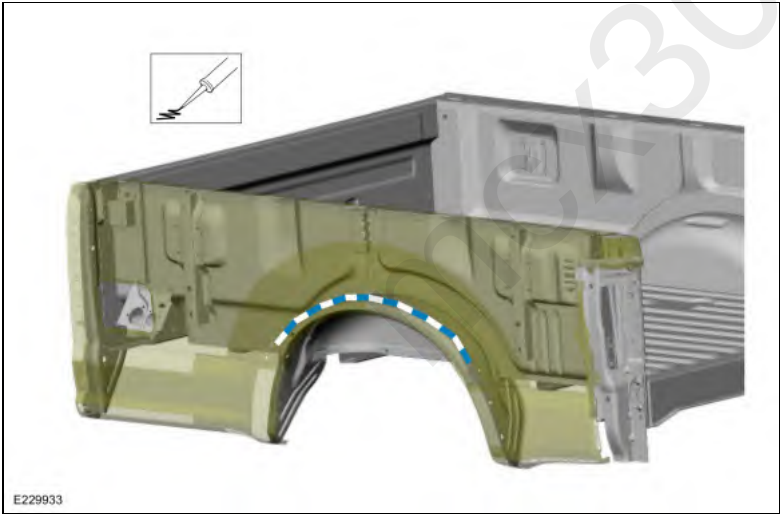
30. Install plug welds with a MIG welder set up for aluminum welding.
 Refer to: Joining Techniques (501-25 Body Repairs - General Information, General Procedures).
 Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).
 Refer to: Welding Precautions (501-25 Body Repairs - General Information, General Procedures).
 Use the General Equipment: MIG/MAG Welding Equipment



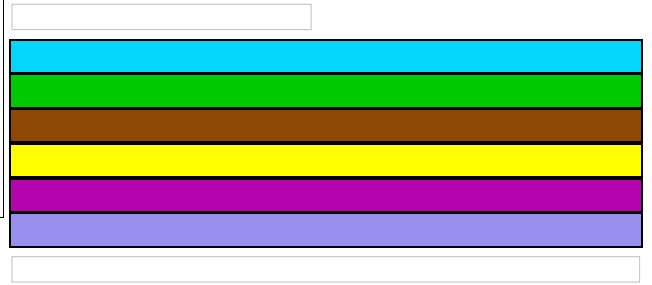
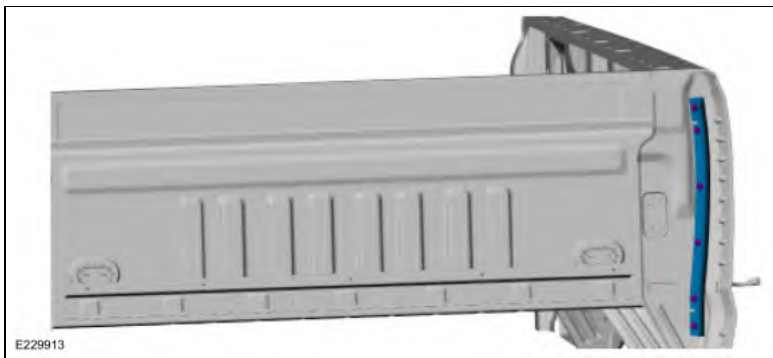
31. Metal finish welds as required using typical aluminum metal finishing techniques and materials.
Refer to: Special Repair Considerations for Aluminum Repairs (501-25 Body Repairs - General Information, Description and Operation).

All vehicles

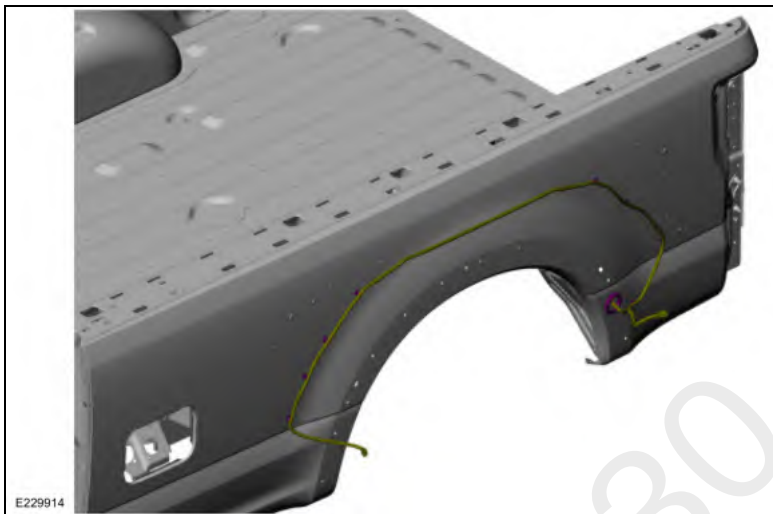
32. Apply NVH foam in location noted during removal.
Material: Flexible Foam Repair / 3M[®] 08463, LORD Fusor[®] 121



33. Refinish the repair using a Ford approved paint system and typical refinishing techniques.
34. Install the cab-to-pickup box seal and fasteners.



35. Install the pickup bed.
Refer to: Pickup Bed (501-04 Pickup Bed and Platform Body, Description and Operation).
36. Dual rear wheels only.
Reposition the dual rear wheels fender wiring harness and install fasteners.



37. Dual rear wheels only.
Install the pickup box dual rear wheels fender.
Refer to: Fender (501-04 Pickup Bed and Platform Body, Removal and Installation).
38. Install the tailgate.
39. Install the tail lamp assembly.
Refer to: Rear Lamp Assembly (417-01 Exterior Lighting, Removal and Installation).
40. LH side only.
Install the fuel fill door and fuel fill cup.
Refer to: Fuel Filler Door (501-03 Body Closures, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Midship Fuel Tank (310-01A Fuel Tank and Lines - 6.2L V8, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Aft of Axle Fuel Tank (310-01A Fuel Tank and Lines - 6.2L V8, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Midship Fuel Tank (310-01B Fuel Tank and Lines - 6.7L Power Stroke Diesel, Removal and Installation).
Refer to: Fuel Tank Filler Pipe - Vehicles With: Aft of Axle Fuel Tank (310-01B Fuel Tank and Lines - 6.7L Power Stroke Diesel, Removal and Installation).
41. Install the top rail cover, wheel house opening and lower side trim.
Refer to: Rear Quarter Panel Moulding (501-08 Exterior Trim and Ornamentation, Removal and Installation).

